

Work Order ID 51961

September 10, 2009 2:58:40 PM

Page 1

Item ID: D350-636-105B

Accept

Revision ID: A

Item Name: Wedge Installation

Start Date: 9/14/09 Start Qty: 4.00

Required Date: 9/24/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9456

A

0.00

0.00

Memo

Photocopy bluefile & type labels per PPP D350-636-105B/ DSI9456
CHG001

8/21/09

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

9/9/30

(42) 54

120

QC4- 100% Inspect kits for completeness

0.00

0.00

Memo

QC

Quality Control

2/ 8/21/09

(42)

54

Work Order ID 51961

September 10, 2009 2:58:40 PM



Page 2

Item ID: D350-636-105B

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wedge Installation

Start Date: 9/14/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D3550-636-105B/ DSI9456

Location:

PPP rev: ~~DSI9456~~ A

9/10/26 40 SH

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

DS-10 22

6 91-00-27

Picklist Print

Page 1

September 10, 2009 2:58:39 PM

Work Order ID: 51961

Parent Item: D350-636-105BRevA

Parent Item Name: Wedge Installation

Comments:

Start Date: 9/14/09

Required Date: 9/24/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S 44 D3926-3RevA	22	Manufactured	No			110	Each	0.0000	8.0000			
Wedge												
S 44 MS21042L3	24	Purchased	No			110	Each	3,754.000	16.0000			
Nut												

5196334

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3754

110844

32

111274

230

111668

992

112314

2000

112385

500

111668 50

S 44 MS24693-S276

Purchased

No

110

Each

146.0000

16.0000

SCREW

96/20 (42) 50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

146

104374

146

104374 50

Picklist Print

September 10, 2009 2:58:40 PM

Page 2

Work Order ID: 51961

Parent Item: D350-636-105BRevA

Parent Item Name: Wedge Installation

Comments:

Start Date: 9/14/09

Required Date: 9/24/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0363J		Purchased	No			110	Each	2.0000	16.0000			



Washer

tested

9/14/09 QWSP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

112314

2

112314

September 10, 2009 2:58:40 PM

Shop Packet Print

Page 2

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skid tubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skid tubes but is not compatible with OEM skid tubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skid tube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skid tube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51966

A	NEW ISSUE		09.07.23
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEDGE KIT	NTS
DATE	09.07.23	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

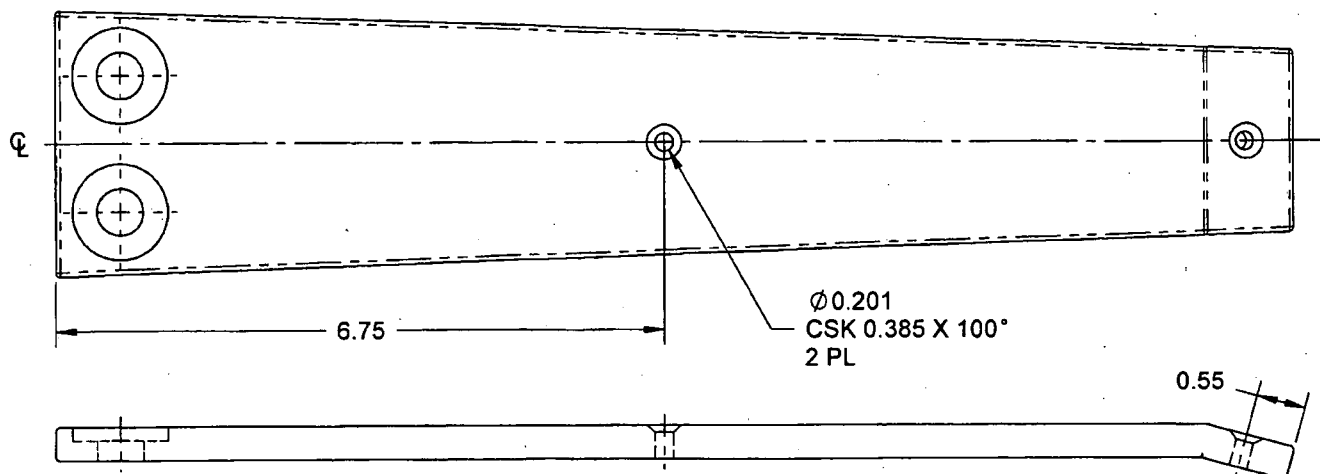


FIGURE 1: D2741 BLADE DRILLING DETAIL

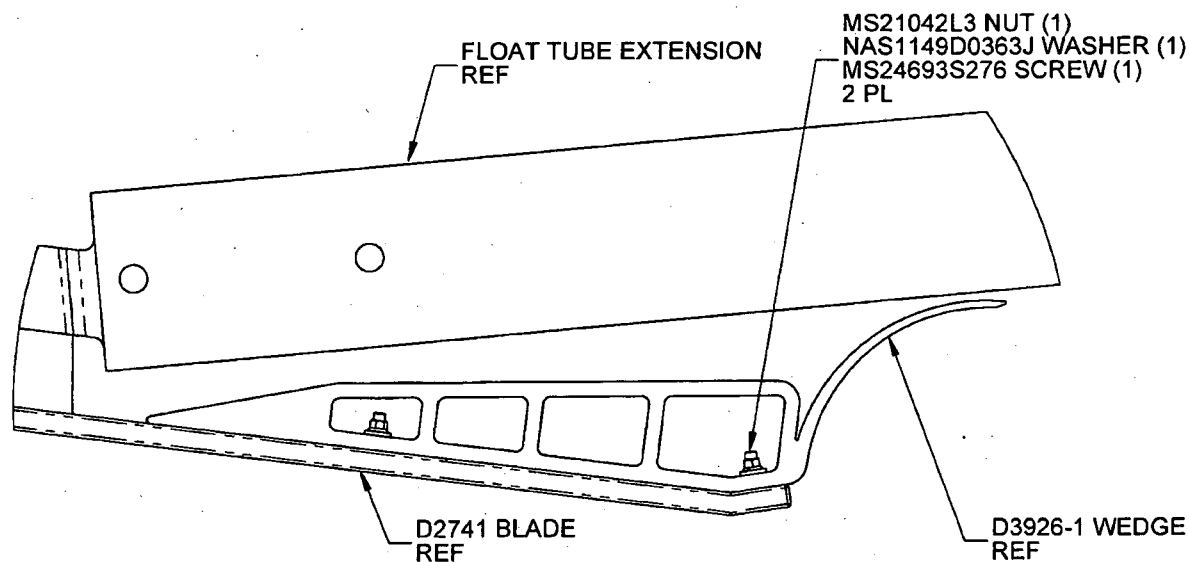


FIGURE 2: D3926-1 WEDGE INSTALLATION

DESIGN	<i>AS</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>AS</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 2 OF 3
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	WEDGE KIT	NTS
DATE	09.07.23	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

1955 02w

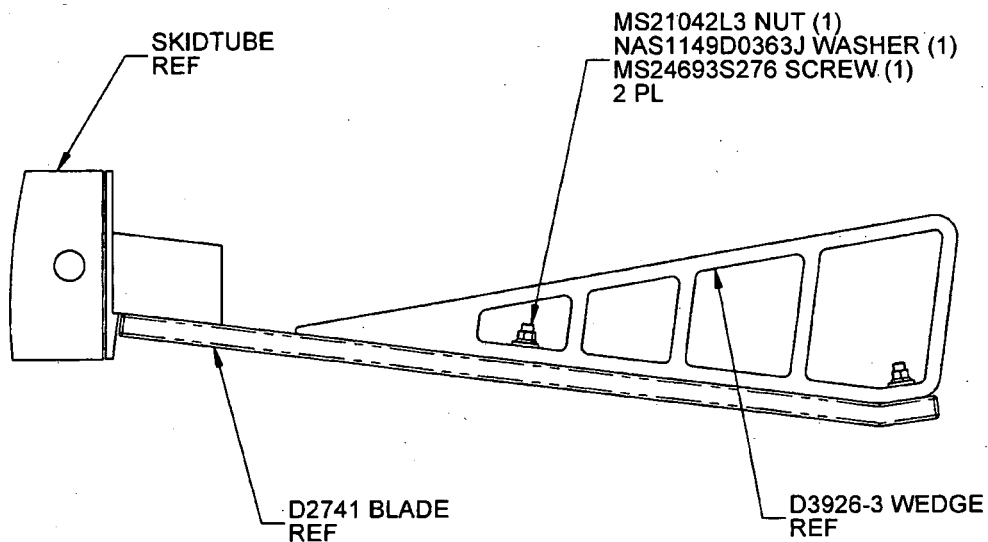


FIGURE 3: D3926-3 WEDGE INSTALLATION

19515
010

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEDGE KIT	NTS
DATE	09.07.23	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skidtubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skidtubes but is not compatible with OEM skidtubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

A	NEW ISSUE	09.07.23
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED	ASS	
MFG. APPR.	N/A	
APPROVED		
DE APPR.		
DATE	09.07.23	
DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. DSI 9456 REV. A SHEET 1 OF 3 TITLE WEDGE KIT SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

Work Order ID 51961

September 10, 2009 2:58:40 PM

Page 1

Item ID: D350-636-105B

Revision ID: A

Item Name: Wedge Installation

Start Date: 9/14/09 Start Qty: 4.00

Required Date: 9/24/09 Req'd Qty: 4.00

Reference:

Drawings: Process Plan:

QC:

Date: 09-09-10

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Reference ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

SI 9456

A

0.00

0.00

Inventory Control

Memo

Photocopy bluefile & type labels per PPP D350-636-105B/ DSI9456
CHG001

Pick Kit

0.00

Tagging

Memo

0.00

Tagging

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Inventory Control

REFERENCE ONLY

09-10-26

9/9/30 (42) 54